

Date: Tuesday, 7/11/2006 1:05:26 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : MOUNTING LUG  
 Job Number : 27866  
 Estimate Number : 10428  
 P.O. Number : N/A Part Number : D32351  
 This Issue : 7/11/2006 S.O. No. : N/A Drawing Number : D3235 REV A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : A  
 Previous Run : 24567 Material : N/A  
 Written By : *Seeg* Comment *Below* Due Date : 7/30/2006 Qty: 60 Um: Each  
 Checked & Approved By : *06.07.11*  
 Comment : Est A 0404.19 New issue KJ/JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2423 Lug Extrusion



Comment: Qty.: 0.0717 f(s)/Unit Total : 4.3029 f(s)

Lug Extrusion

D2423 extrusion

Batch: \_\_\_\_\_

*323778*

*f 61*

*EP 06/07/13*

2.0 BAND SAW BAND SAW



Comment: Band Saw

Cut D2423 extrusion to 0.820"

Batch: \_\_\_\_\_

*323749*

*61*

*06/07/13*

3.0 HAA91 HAAS CNC VERTICAL MACHINING #1

*PG*



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA369 and Dwg D3235

2-Identify as D3235-1

3-Deburr and Tumble

*issue P.O. 1684*

*machine per drawing  
D3235-Rev. A*

*06/07/14*

4.0 *RG* *Q82* INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*Review + Inspect*

*AP 06/08/15 61*

5.0 *Q85* SECOND CHECK



Comment: SECOND CHECK

*06/08/15*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/08/17

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: MOUNTING LUG

Job Number: 27866

Part Number: D32351

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*a.m 06-08-15*

*(60)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

*a.m 06-08-16*

*(61)*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*AL 06/08/16*

*(61)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST94*

*AL 06/08/16 (61)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*AL 06/08/17*

Job Completion



*C2del08/17*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

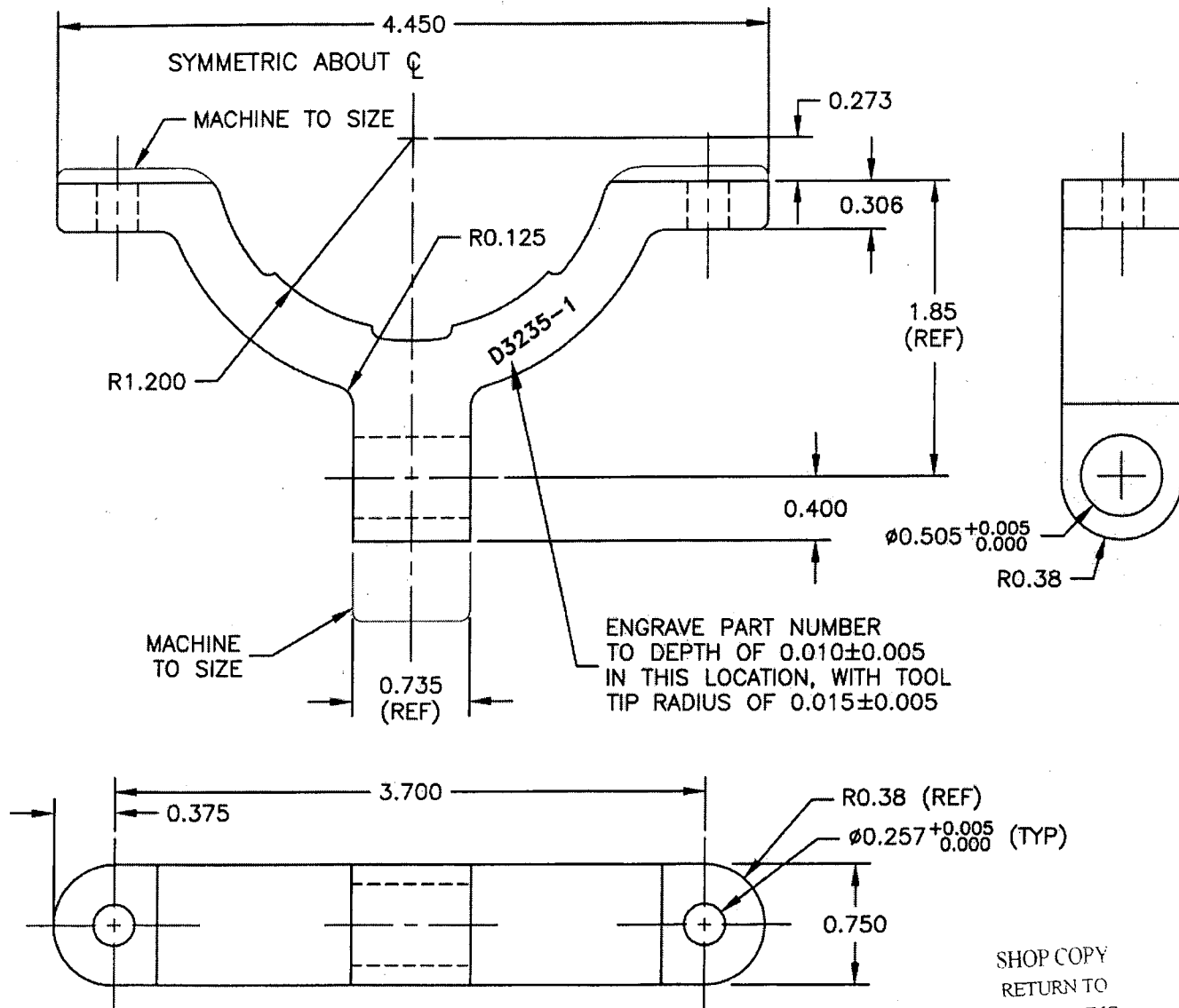
NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3235	REV. A SHEET 1 OF 1
DATE 04.03.02		TITLE MOUNTING LUG	SCALE 1:1
A	04.03.02	NEW ISSUE	

RELEASED  
04.04.05 *#*



**D3235-1 MOUNTING LUG**

MAKE FROM EXTRUSION D2423

BREAK ALL EDGES 0.000-0.015

FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27866

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Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
61	D 3235-1	Mounting Lug	1686

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

Shigi (Regula) Walz

Vankleek Hill, August 14, 2006

